

Date: Wednesday, 28/02/2007 1:54:43 PM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 1/4 TURN FASTNER RAIL (BLACK)		
Job Number	: 30988	Part Number	: D103858B		
Estimate Number	: 10096	Drawing Number	: D1038		
P.O. Number	: N/A	Project Number	: N/A		
This Issue	: 28/02/2007	S.O. No.	: N/A		
Prsh Rev.	: NC	Type	: MACHINED PARTS		
First Issue	: N/A	Material	: N/A		
Previous Run	: 30255	Due Date	: 16/03/2007 Qty: 100 Um: Each		
Written By					
Checked & Approved By					
Comment	: Est: E 03.05.02 Reformat; Added label KJ/RF Est Rev:F 06-08-16 Updated Packaging Procedures JLM				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	DC	DOCUMENT CONTROL
		Comment: DOCUMENT CONTROL Create white labels and bag them
2.0	D2023	Extrusion, Fastener Rail 1.903
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 100.0000 Each(s) Extrusion, Fastener Rail Batch: B21507
3.0	BAND SAW	BAND SAW 53.77 216.99
		Comment: BAND SAW Cut extrusion D2023 to length 21.81" (+0.06/-0.00)
4.0	HAAS1	HAAS CNC VERTICAL MACHINING #1 53.77 216.99
		Comment: HAAS CNC VERTICAL MACHINING #1 1-Machine as per Folio and Dwg D1038-58
5.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE 53.77 216.99
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

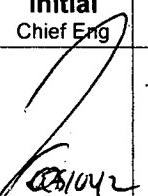
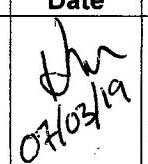
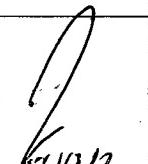
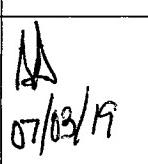
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 07/03/19
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/03/19	4.0	-2D parts scrap holes out of tol. not centered	 07/03/19	-destroy	 07/03/19	 07/03/19	 07/03/19	

NOTE: Date & initial all entries

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Drawing Name: 1/4 TURN FASTNER RAIL (BLACK)

Job Number: 30988

Part Number: D103858B

Job Number:



Seq. #:	Machine Or Operation:	Description :
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13.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

1/4 turn 16

14.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

1-Pack each fastener rail into a cardboard tube

2-Roll Part in foam .

3-Install red cap at each end and secure with tape.

4-Apply white labels to cardboard tubes

5-Identify and Stock

Location: _____

DMS/T

2/8/17 (8)

15.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

2/8/17 (8)

Job Completion



Linda Lacelle

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	30988
Description: 1/4" Turn Fastener	Part Number:	D1038-58B
Inspection Dwg: D1038-58B Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

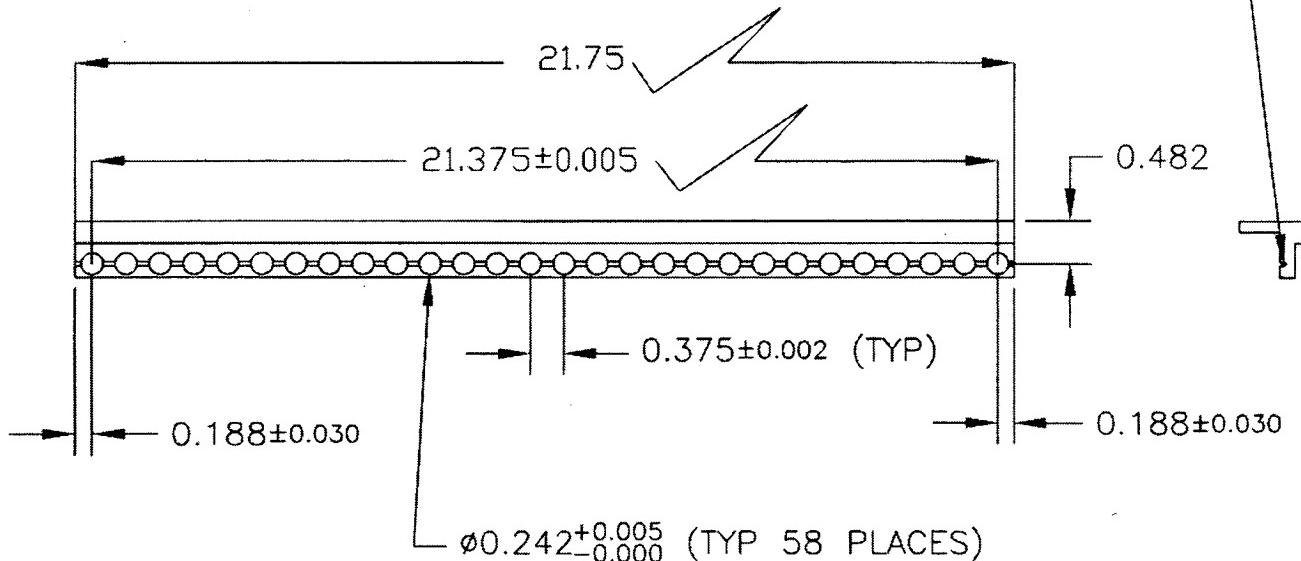
X First Article Prototype

Measured by:	Up	Audited by:	SD	Prototype Approval:	N/A
Date:	07/03/01	Date:	07/03/01	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.02.16	New Issue	KJ/JLM	
B	06.03.08	21.750 was 12.750, Dwg rev. changed	KJ/JLM	

DARTDESIGN
44DRAWN BY
*J.S.*DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

REV. B

CHECKED
*J.H.*APPROVED
*J.H.*DRAWING NO.
D1038SHEET 1 OF 1
SCALE
NTSDATE
05.02.02TITLE
1/4 TURN FASTENER RAIL91.05.05
NEW ISSUEDATE
04.05.14TITLE
UPDATE TOLERANCEB
05.02.02TITLE
REDRAWN, UPDATE NOTESRELEASED
05.03.31
*[Signature]*STAKE Ø0.50 TYPE 302 STAINLESS
STEEL WIRE FULL LENGTH
(REF DART SPEC M302SW.050)**D1038-58 1/4 TURN FASTENER RAIL**

- 1) MAKE FROM D2023 EXTRUSION
- 2) FINISH: D1038-58 - NONE
D1038-58B - ANODIZE BLACK PER DART QSI 017 4.1.10
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

WJ 30988
121
0.351
0.361
0.371

17

13

30

30

60



21 chemin de l'Aviation, Pointe Claire QC H9R 4Z2

Telephone: (514) 429-7777 Fax: (514) 429-5108

Certifié ISO 9001-2000 / AS9100 certified

approuvé NADCAP approved

54136

30-Mar-2007

CLIENT / CUSTOMER:**DART AEROSPACE LTD.**1270 ABERDEEN STREET
HAWKESBURY ONTARIO
K6A 1K7**CERTIFICATE OF COMPLIANCE**
CERTIFICAT DE CONFORMITE**PURCHASE ORDER/**
NO. DE COMMANDE:

00003393

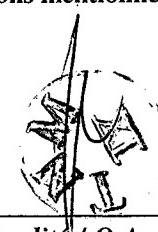


ITEM	COMMANDE ORDERED	EXPEDIE SHIPPED	PART NUMBER & DESCRIPTION	PART PROCESS & TREATMENT
1	80	80	D103858B B30988	REV. B BLACK ANODIZE PER MIL-A-8625F1 TYPE II CLASS 2 ALL OVER

REQUIREMENTS HAVE BEEN IN ACCORDANCE WITH MD-INC P.R.I.D.E. MANUAL

Nous certifions que les pièces énumérées ont été traitées, testées et inspectées selon les spécifications mentionnées.
Les cartes de travail ont été remplies et sont disponibles pour consultation, sur demande.

All parts are processed, tested, and inspected to the requirements of above specifications.
Travel cards have been filed and are available for viewing upon request.

*Signature/Signed:* _____ Directeur de la Qualité/ Q.A. Manager